

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013182**Date Inspected:** 06-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

7AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA031 cross beam side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1229 repair procedure.

Y Location of repairs areas by above noted welder (045221) is located at 6800, 8360, 8630 and 8690mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA032 cross beam side of segment. Welder is identified as Mr. Ge Tao (067765). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1223 repair procedure.

Y Location of repairs areas by above noted welder (067765) is located at 6790mm.

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA031 counter weight side of segment. Welder is identified as Mr. Ge Tao (067765). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1229 repair procedure.

Y Location of repairs areas by above noted welder (067765) is located at 2950 and 3940mm.

7BW+7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 13 and 14 located at EP058-001 counter weight side of segment. Welder is identified as Mr. Fang Xianyou (037748). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

7CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA038 cross beam side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1228 repair procedure.

Y Location of repairs areas by above noted welder (045221) is located at 8020mm.

7AW+7BW

Shield Metal Arc Welding (SMAW) VT repair welding was performed on various t stiffeners located on the side plates and bottom plate of segment. Welder is identified as Mr. Zhou Songsong (068091). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

Shield Metal Arc Welding (SMAW) VT repair welding was performed on various t stiffeners located on the side plates and bottom plate of segment. Welder is identified as Mr. (068091). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Trail Assembly yard. Locations and description of work are as followed:

8BE, 8CE and 8CW

1. Observed segment being moved in the trail assembly yard for field splice fit up work.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
